

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2015-62 Date Opened: 02-Jun-15 Title: Assembly

Aircraft OEM: Eurocopter Aircraft Model: AS350/355 Product Type: Cargo Basket & Lid Product Model: XL Quantity: 2

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
N/A
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94010	1	Basket	JR
94011	1	Body	JR
94012	1	Lid	JR
94023	1	Attachment Hoop	JR
94027	1	Data Card	JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

2
N/A
N/A
JR

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JR
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: Jason Rekve

Sign: [Signature]

SCA: AD01

Date: 05-Jun-15

ICC / Dual Inspection performed by:

Print: Jeff Clarke

Sign: [Signature]

SCA: AD02

Date: 05-Jun-15

Work Order closed by:

Print: Jason Rekve

Sign: [Signature]

SCA: AD01

Date: 05-Jun-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

CARGO BASKET HOOP FABRICATION - 94023

General

These instructions apply to cargo basket attachment hoop 94023-01. Refer to the following drawings, at the current revision, for dimensions and details:

94023, Revision 0 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

Work Order: 2015-62

Date Open: 2 Jun 15

Complete
(initial or SCA #)



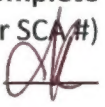
1. ½ Hoop Fabrication – ½" hoop

- a. Cut ½" x 0.035 material to 23.0", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: ??"
 - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Check for:
 - i. hoop height: 18" (Outside to outside)
 - ii. adjust upper stop for height if required



2. ½ Hoop Machining – ½" hoop – Handle Provisions 84262-01

- a. Start with ½" half hoop from step 1.
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
 - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.



3. ½ Hoop Fabrication – 1" hoop

- a. Cut 1" x 0.065 material to 30.0", on end square, one end @ 16 degrees.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
 - i. Upper tube stop: ??
 - ii. Lower bend stop: ??
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for angle using hoop jig. Adjust stops if required.
- j. Check for:
 - i. hoop height from jig
 - ii. adjust upper stop for height if required
 - iii. length to allow 60 degree cut.
- k. Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- l. De-burr cut end using a sanding disc on a die-grinder or disc sander.



4. ½ Hoop Machining – 1" hoop

- a. Start with 1" ½ hoop as stock.
- b. Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.75" and set X 0. Shift Y -0.5". Set stop against end of tube.
- c. Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Set tube in vise with 60 degree end on right.
- f. Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- g. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- h. Tag in process hoop(s) and place into stock.



5. Joint Preparation

- a. Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.
- b. Insert one 94023-05 lug (flat end) at top and 94023-07 lug (angled end) at bottom into holes in 1" hoop. Seat top lug flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop. Mark 94023-07 lug and trim or grind to fit.

AD-05

6. Welding – Lugs

- a. Insert one 94023-07 lug (flat end) at top and 94023-05 lug (angled end) at bottom into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 16 7/8" spacing jig with 3/8-24 bolts to lugs and space jig 7/8" out from hoop.
- b. TIG weld all around both sides of lugs. 2 places. Grind angled lug into radius of hoop before welding.
- c. Record lug and welding rod PO/WO on attached material list.

7. Welding – Handle Bushings – 84262-01

AD-05

- a. Insert 84271-01 bushings into 1/2" hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.

8. Welding – Hoop Assembly

AD-05

- a. Insert 1" hoop from step 6 and 1/2" hoop from step 7 into hoop jig. Seat 1/2" hoop into slot in 1" hoop.
- b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- c. TIG weld around 1/2" hoop in slot.
- d. Cap 1/2" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- e. Record cap and welding rod PO/WO on attached material list.

9. Finishing and Inspection

OR

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2015-62

Date Open: 2 Jun 15

AK

1. Rim Assembly – Basket Body

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD-05

3. Inspection

- a. Rim for complete welds

AK

4. Frame assembly – body

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 1. Attachment lugs are on inboard side.
 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

AK

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

AD-05

6. Inspection

- a. Frame assembly for complete welds.

AK

7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

AK

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)
AD-05

8. Weld mesh to frame assembly per drawing.

- a. Ensure lug locating jig is in place prior to welding.
- b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
- c. Bend and trim cells bent in to fit mesh as required and weld in position.
- d. Grind high spots off body mesh welds on ends before welding end mesh.
- e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
- f. Record welding rod PO on attached material list.

9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

AD-05

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

AK

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

AK

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2015-62

Date Open: 2 Jan 15

AK

1. Rim Assembly – Basket Lid

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.

2. Weld Rim Assembly

- a. Record welding rod PO on attached material list.

AD-05

AK

3. Inspection

- a. Rim for complete welds

AK

4. Frame assembly – Lid

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- b. Insert rim from step 2 into jig.
- c. Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- d. Record material PO on attached material list.
- e. Remove writing on tubes with acetone and scotch bright.
- f. Drill vent holes into rim to vent cross members into rim.
- g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

AK

5. Frame assembly – Lid with optional walkway modification

- a. Fit cross members to rim in accordance with step 4.
- b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- c. Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- d. Drill vent holes into cross members at walkway stringers.
- e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

AD-05

6. Weld frame assembly.

- a. Record welding rod PO on attached material list.
- b. Jigs must remain in place for as long as practical during welding.

AK

7. Inspection

- a. Frame assembly for complete welds.

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for lid.
- c. Remove surface rust with scotch-brite.
- d. Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing.

AD-05

- a. General welding requirements for all lids:
 - i. Every intersection on all edges.
 - ii. First 5 intersections along cross members, then every second intersection.
- b. MIG weld both short sides.
- c. Clamp lid over spacer at centre of lid to pre-tension mesh.
 - i. $\frac{3}{4}$ " for lids under 76"
 - ii. 1" (check) for lids over 76"
- d. Weld remainder of mesh as indicated in a.
- e. Record welding rod PO on attached material list.

10. Weld lid components.

AD-05

- a. Handle brackets, locate in accordance with drawing.
 - i. Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - ii. Record handle bracket WO and welding rod PO on attached material list.
- b. Lid prop bushing(s).
 - i. one or two in accordance with drawing.
 - ii. Record lip prop bushing WO and welding rod PO on attached material list.
- c. Placard bracket. – not installed on 95912 (Bell 429)
 - i. Locate on cross member to set bracket in centre bay of lid.
 - ii. Record placard bracket WO and welding rod PO on attached material list.

11. Clean up

AK

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- c. Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- d. Drill #9 through lid prop bushing(s). De-burr hole(s).
- e. Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.
 - i. 3 places for lids under 76"
 - ii. 4 places for lids over 76"
- f. Remove surface rust with scotch-brite pad.

12. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket lid assembly for complete welds, and required minimum mesh weld locations.
- b. Material lists complete.
- c. Overall condition and conformity to drawing(s).

JC

CARGO BASKET LID FABRICATION

Complete
(initial or SCA/#)



13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

Work Order: 2015-62Date Opened: 02 Jun 15

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
		94011	94011-01	Basket Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14099
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14099
	. 1		--	3/4" Tube - Long Stringer (95.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14099
	. 4		--	3/4" Tube - Short Stringer (2.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14099
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
	. 2		94023-01	Hoop - attachment		14099
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
Step 4.g.		70406	70406-01	<i>Option: Front End Cutout</i>		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
Step 6				<i>Inspection - Frame Assembly</i>	None	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	14012
	. 2		--	Mesh (End - 25" x 18")	3/4-16F Expanded Mild Steel sheet	14012

Work Order: _____

Date Opened: _____

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

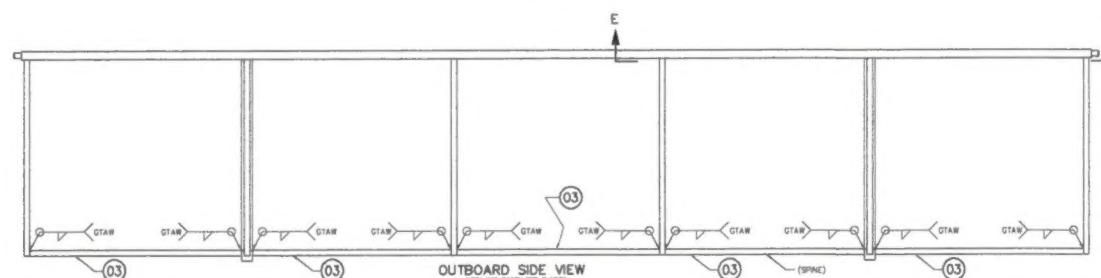
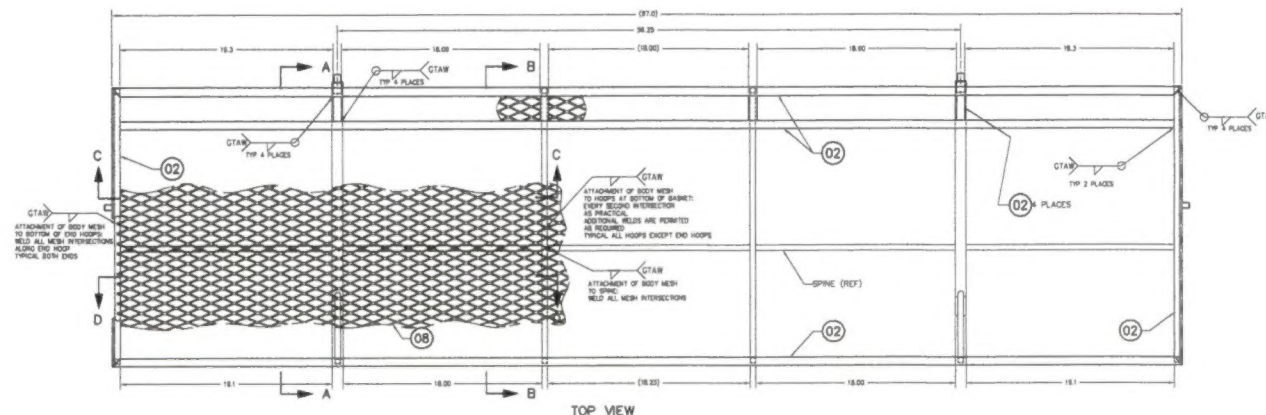
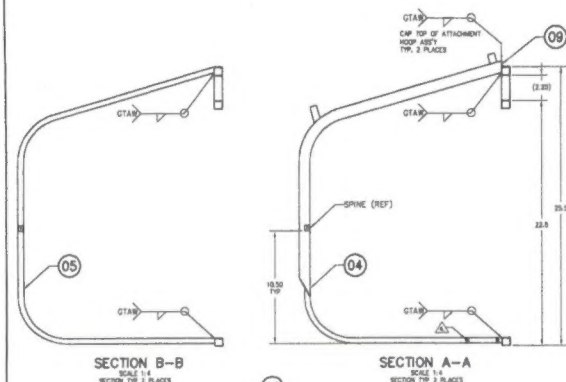
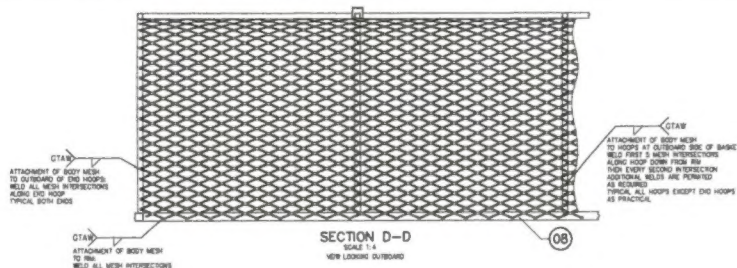
2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				Weld Mesh		
	A/R		--	Welding Rod	ER70S-6 MIG Wire	14028
Step 9				Weld Basket Components		
	2		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	2015-07
	A/R		--	Welding Rod	ER308L TIG Rod	14033
Step 10				Clean Up	None	
Step 11				Inspection - Final Assembly	None	
Step 12				Powder Coating		

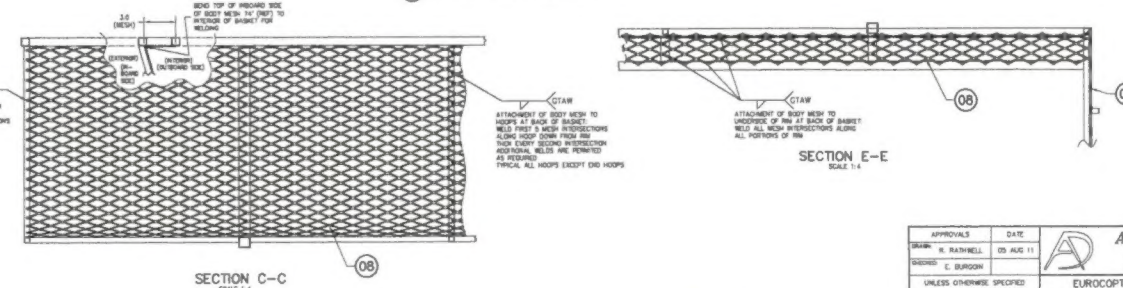
x2

2015-62

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INITIAL ISSUE		
2	WELD BLOCK UPDATES: WELDING ROD UPDATES: REFERENCE DMS ADDED		11/07/2014
3	NEW DIMENSIONS UPDATED: WELDS DOWN (DOES NOT AFFECT)		



01 BASKET BODY ASSEMBLY

SECTION C-C
SCALE 1:4
VIEW LOOKING INBOARD

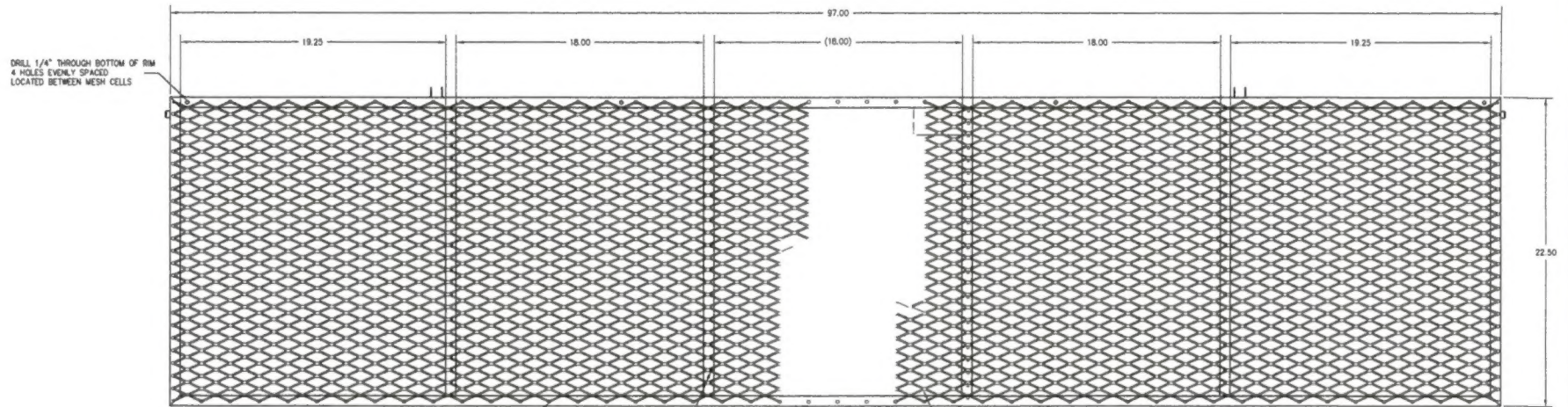
- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. PRIOR TO WELDING, DRILL AND (0.010) VENT HOLES IN ASSEMBLY FOR WEAVING OF WELD GABES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
 3. WELDING OF 4130 STEEL TO BE COMPLETED BY CTAW METHOD TO AHS 2800C.
 4. 4130 AND 1018 STEEL WELDING ROD SHALL CONFORM TO AWS A5.28 OR EQUIVALENT.
 5. STAINLESS AND 4130 STEEL WELDING ROD SHALL CONFORM TO EXCEL OR EQUIVALENT.
 6. INSTALL ITEM 7 (BASKET HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 8485 BEFORE WELDING HOOPS TO FIN.
 7. FINISH: THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY.

REV	DESCRIPTION	MATERIAL	QUANTITY	UNIT
1	01 TOP	WELD STEEL	1	1/2" x 1/2" x 1/2"
2	02 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
3	03 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
4	04 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
5	05 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
6	06 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
7	07 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
8	08 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
9	09 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
10	10 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
11	11 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
12	12 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
13	13 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
14	14 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
15	15 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
16	16 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
17	17 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
18	18 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
19	19 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"
20	20 1/2" x 1/2" x 1/2"	WELD STEEL	1	1/2" x 1/2" x 1/2"

APPROVALS	DATE	APPROVALS	DATE
DESIGNED: E. BURTON	20 AUG 11	DESIGNED: E. BURTON	20 AUG 11
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES IN:		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES IN:	
DECIMALS	ANGLES	DECIMALS	ANGLES
0.001 ±0.010	0.1°/2°	0.001 ±0.010	0.1°/2°
0.005 ±0.003		0.005 ±0.003	
0.01 ±0.1		0.01 ±0.1	
SHEET 1 OF 1		SHEET 1 OF 1	

AERO DESIGN LTD.	
POWELL REYNOLDS, BC, CANADA, V8A 0G8	POWELL REYNOLDS, BC, CANADA, V8A 0G8
EUROCOPTER AS330 & AS350 SERIES	EUROCOPTER AS330 & AS350 SERIES
QUICK RELEASE CARGO BASKET	QUICK RELEASE CARGO BASKET
BASKET BODY ASSEMBLY (EXTRA LARGE)	BASKET BODY ASSEMBLY (EXTRA LARGE)
SCALE 1:4	SCALE 1:4
NO. 94011	NO. 94011
REV. 1	REV. 1

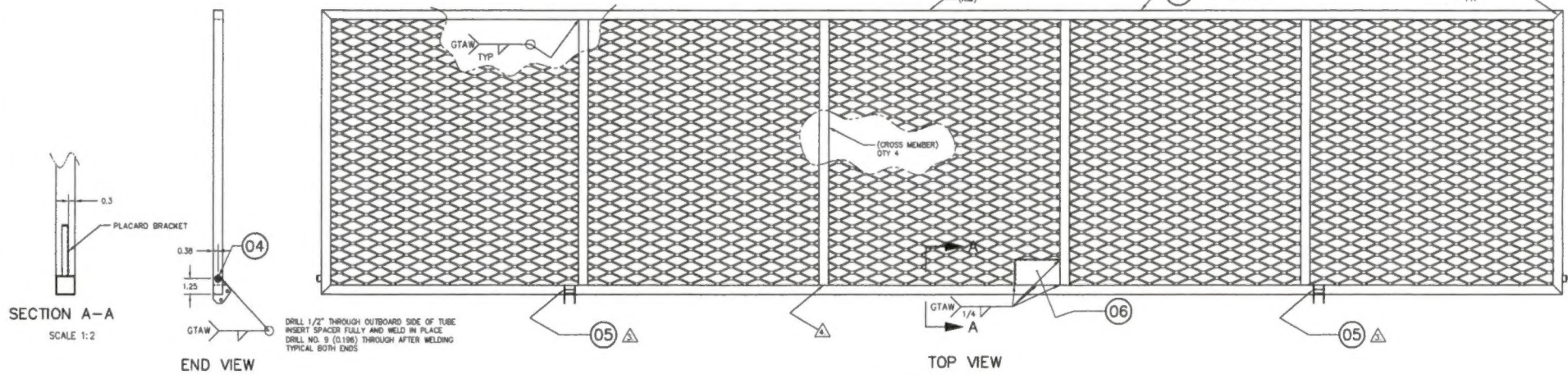
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DISSEMINATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; CHANGED 36273-01 TO 84263-01; ITEM #'S ADDED	BJC	10/07/2014
	WELDING ROD UPDATED; # OF WELDS DOWN BRACE TUBES INCREASED		



GTAW TYP
ATTACHMENT OF MESH TO RIM
WELD EACH INTERSECTION

GTAW TYP
ATTACHMENT OF MESH TO CROSS MEMBERS
WELD FIRST FIVE INTERSECTIONS
THEN EVERY SECOND INTERSECTION
ADDITIONAL WELDS ARE PERMITTED AS REQUIRED

BOTTOM VIEW (03) MESH



SECTION A-A
SCALE 1:2

END VIEW

TOP VIEW

(01) LID ASSEMBLY

NOTES:

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C.
4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263.
4. DRILL #30 (0.129) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	36204-10	06	PLACARD BRACKET			
1	84263-01	05	LID HANDLE PROVISIONS ASSEMBLY			
2	49216-01	04	SPACER			
A/R	3/4 - 18"	03	MESH	MILD STEEL	COMMERCIAL	
A/R		02	SQUARE TUBE	4130 STEEL COND. N	MIL-T-6736	0.75 X 0.035 SQR TUBE
	94012-01	01	LID ASSEMBLY			

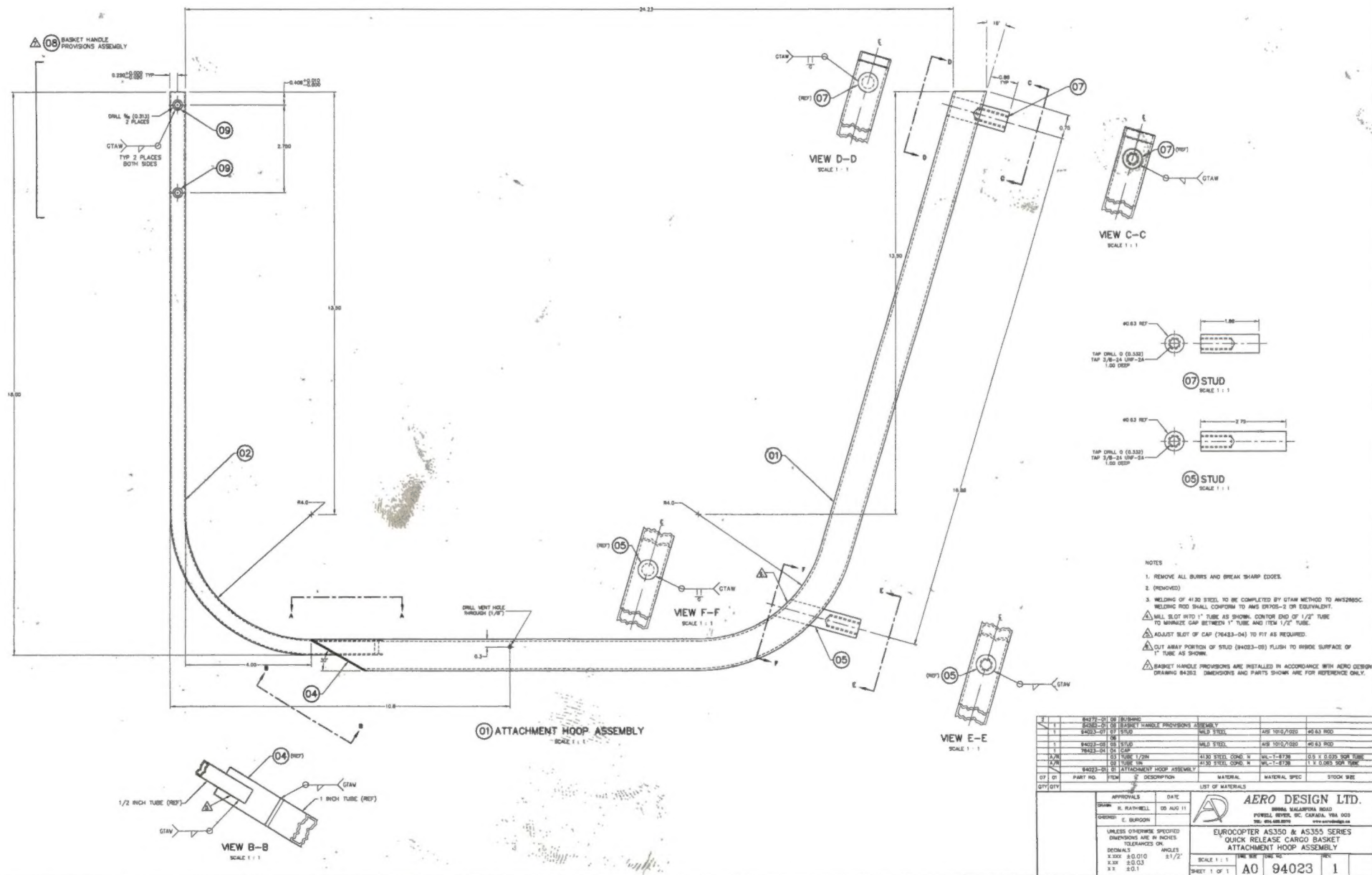
LIST OF MATERIALS

APPROVALS		DATE		
DRAWN: R. RATHWELL		05 AUG 11		
CHECKED: E. BURGON				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				
DECIMALS			ANGLES	
X.XXX ±0.010			±1/2°	
X.XX ±0.03				
X.X ±0.1				
SCALE 1: 4		DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1		A1	94012	1

AERO DESIGN LTD.
6088A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.5276 www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
LID ASSEMBLY (EXTRA LARGE)

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
01	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; 176N #15 UPDATED; 84282 HANDLE PROVISIONS ADDED	BJC	11/07/80





AS350 SKI x1 BODY
2015-62 x1 LID

WO# _____

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013